

Date: Friday, 15/02/2008 10:46:59 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 37475
Estimate Number : 10716
P.O. Number :
This Issue : 15/02/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 11 Type : MACHINED PARTS
Previous Run : 37470
Written By :
Checked & Approved By :
Comment : Est Rev:A 04.02.18 New issue KJ/DS
Est Rev:B ECN 1060 07-11-12 DD verified by:EC

Drawing Name : BEARING ASSEMBLY
Part Number : D3121241
Drawing Number : D3121 REV E
Project Number : N/A
Drawing Revision : E
Material :
Due Date : 22/02/2008 Qty: 40 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MDELNR12500 DELRIN ROUND BAR 1.25"



60

Comment: Qty.: 0.0546 f(s)/Unit Total : 2.1840 f(s)
Material: Ø1.25 Delrin Rod
(M-DELNR-R1.2500)Identify as D3121-25
Batch: M104394

Y A

08/02/16

2.0 HARDINGE HARDINGE CNC LATHE SMALL



60

Comment: HARDINGE CNC LATHE SMALL

1-Turn D3121-25 Cap as per Folio FA387

2-Deburr

Y A / ml

08/02/16

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



60

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Y A / ml

08/02/16

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Y A / ml

60

5.0 D312123 Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-23

Bearing

36675 36670

2

U 08-02-20

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Part Number: D3121241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

U 08.02.20 (2)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

U 08.02.20 (2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 238

U 8/2/20 50 (4)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.02.20

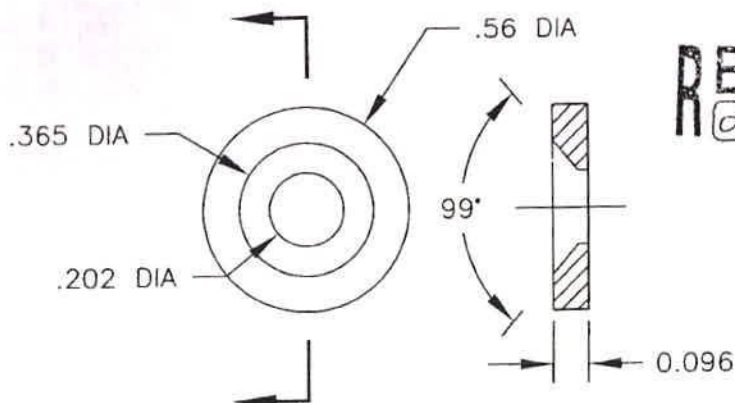
Job Completion



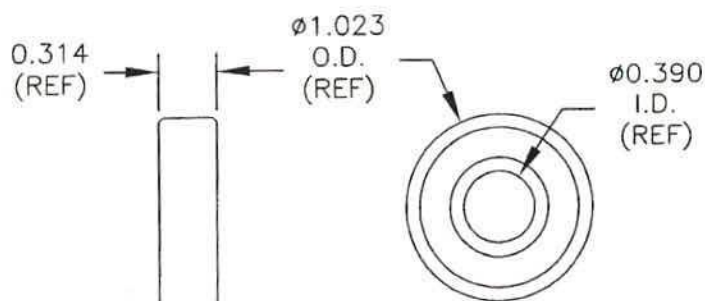
U 08.02.20

DART

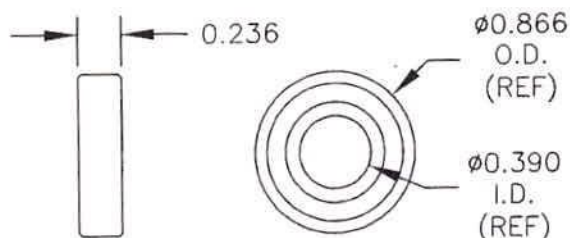
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

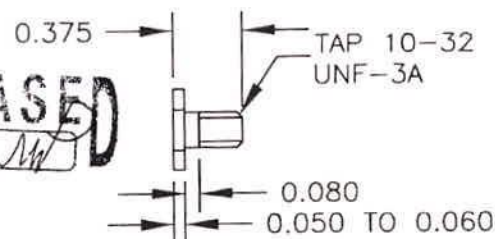
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

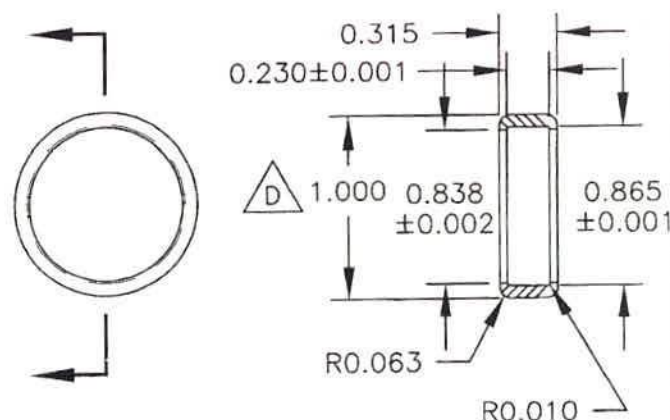
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

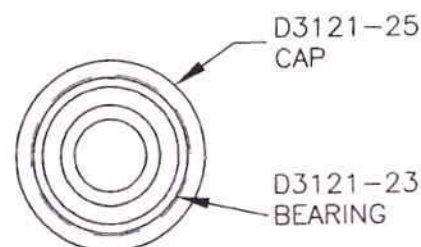
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, $\phi 1.25$ (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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